

XPRO® SP200 P 3085

Automotive certification: General Motors, GM-GMP.PP.123



OVERVIEW:

- ♦ Automotive certification: General Motors, GM-GMP.PP.123
- ♦ Polypropylene Copolymer, recycled, medium flow
- ♦ Processing—Injection Molding
- ♦ Application—Automotive general purpose, automotive wheel housings
- ♦ Color—General Purpose Black
- ♦ Low cost alternative to virgin resin with comparable quality and process ability.
- ♦ Quality: ISO 9001:2015 registered, IEC 17025: 2005 accredited laboratories, COA on every lot.

PROPERTY	VALUE	UNITS	TEST METHOD
Melt Flow	17-22	g/10 min	ASTM D1238 / ISO 1133
Izod Impact Notched @ 23° C	3.2	Ft lbs/in	ASTM 256 / ISO 180/A
Tensile @ Yield	2500	psi	ASTM D638 / ISO 527-1/2
Flexural Modulus 0.05 in/min	110,000	psi	ASTM D790 / ISO178

GENERAL INJECTION MOLDING GUIDE

Barrel Temperature: Rear 360° F to 420°F Middle-380° F to 440°F Front-400° F to 420°F
Nozzle Temperature: 400°F – 420°F
Melt Temperature: 400°F – 440°F
Mold Temperature: 80°F – 140°F
Molding Pressure: Boost-500 to 1,500 psi Hold-50 to 75% of Boost Back-50 to 150 psi
Screw Speed: Medium to Fast
Clamp Force: 2 to 2.5 tons per square inch part projected area
Drying: 2 to 4 hours @ 180°F

IMPORTANT: The following supersedes buyer documents. Seller makes NO WARRANTY, REPRESENTATION OR CONDITION OF ANY KIND, EXPRESS OR IMPLIED (INCLUDING NO WARRANTY OF MERCHANTABILITY OR FITNESS OF THE GOODS FOR ANY USE CONTEMPLATED BY BUYER) concerning the Goods and none shall be implied by law. Final determination of the suitability of the Goods for the use contemplated by Buyer is the sole responsibility of Buyer, and Seller shall in no way be responsible for the suitability of the Goods for any particular end use.